

Date: Thursday, 06/11/2008 2:31:48 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : INNER AFT SADDLE
<b>Job Number</b> : 43248	
<b>Estimate Number</b> : 11082	
<b>P.O. Number</b> :	<b>Part Number</b> : D5957
<b>This Issue</b> : 06/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D5957 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 39796	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/11/2008 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.06</u>	
<b>Comment</b> : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: ~~B38696~~ B34875 X 4 PCS

B 41960 x 2 PCS

J.F. 08/11/11

⑥

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

J.F. 08/11/11

⑥

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

J.F. 08/11/11

⑥

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/11/21

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-J

08/11/22

⑥x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/11/2008 2:31:48 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 43248

Part Number: D5957

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

POWDER COATING

POWDER COATING



M 109152



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00  
320 OF  
8:30

M-1 08/11/24

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (x6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P-8/4/24 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43248
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440"	0.440"	0.440"	0.440"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	5.245	5.255		5.249"	5.249"	5.249"	5.249"		
D	6.995	7.005		6.999"	7.000"	7.000"	7.000"		
E	5.240	5.260	5.250	5.250"	5.250"	5.250"	5.250"		
F	4.745	4.755		4.748"	4.748"	4.748"	4.748"		
G	0.315	0.322		0.320"	0.320"	0.320"	0.320"		
H	1.522	1.532		1.527"	1.527"	1.528"	1.528"		
I	3.048	3.058		3.053"	3.053"	3.054"	3.054"		
J	4.575	4.585		4.580"	4.580"	4.580"	4.580"		
K	0.315	0.322		0.320"	0.320"	0.320"	0.320"		
L	0.495	0.505		0.500"	0.500"	0.500"	0.500"		
M	0.490	0.510		0.499"	0.499"	0.499"	0.499"		
N	1.865	1.885		1.875"	1.875"	1.875"	1.875"		
O	7.990	8.010		8.000"	8.000"	8.000"	8.000"		
P	2.240	2.260		2.250"	2.250"	2.250"	2.250"		
Q	0.307	0.312		0.311"	0.309"	0.309"	0.310"		
R	0.760	0.765		0.760"	0.760"	0.760"	0.760"		
S	0.490	0.510		0.505"	0.506"	0.504"	0.503"		
T	1.625	1.645		1.630"	1.632"	1.631"	1.631"		
U	2.000	2.020		2.025"	2.007"	2.006"	2.006"		
V	0.023	0.043		0.033"	0.033"	0.033"	0.033"		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F. mwe
Date:	08/11/11 02/11/18

Audited by:	J.L.
Date:	08/11/21

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 143248
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

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S	0.490	0.510		0.503"	0.503"				
T	1.625	1.645		1.631"	1.631"				
U	2.000	2.020		2.006"	2.006"				
V	0.023	0.043		0.033"	0.033"				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

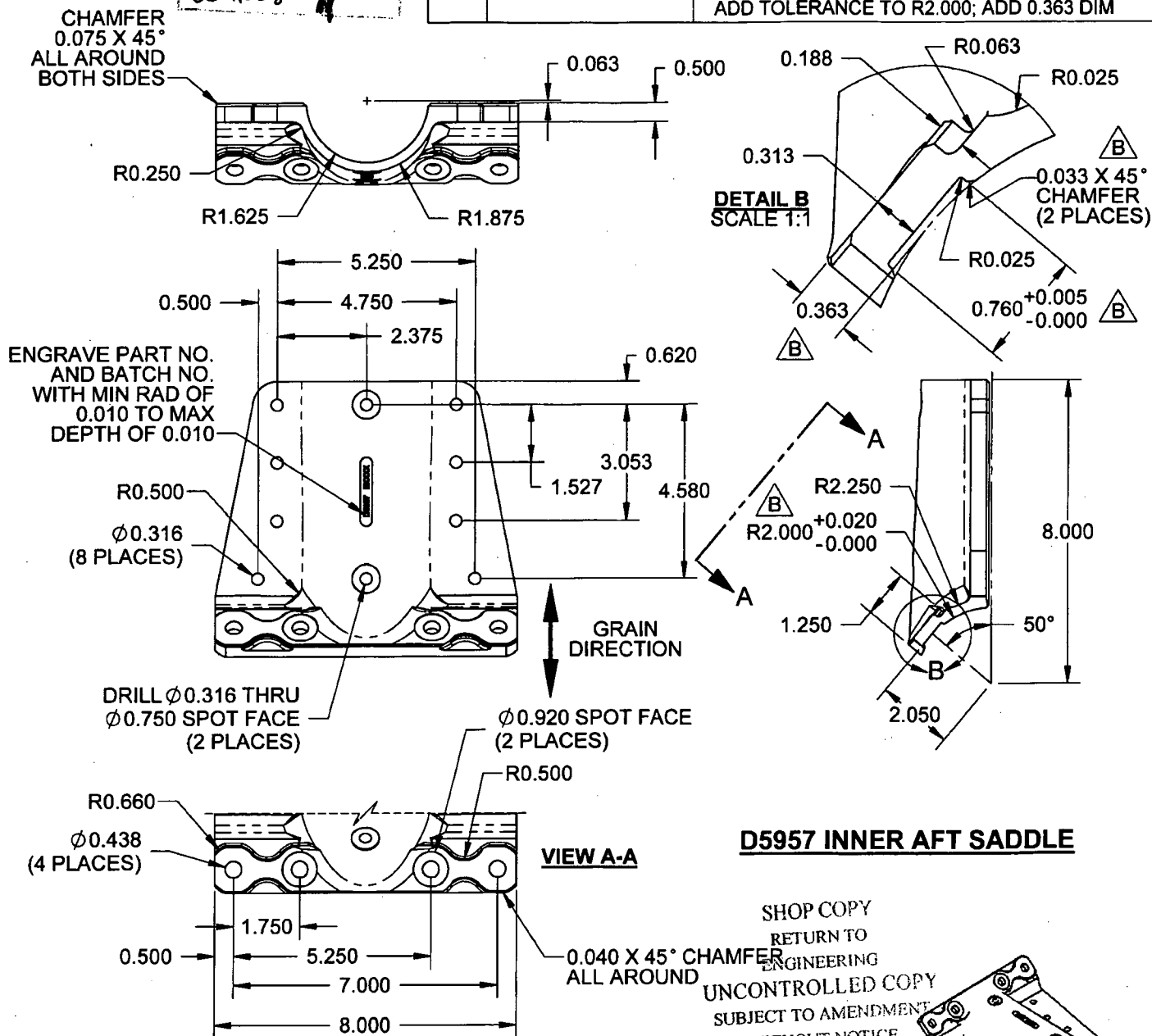
Measured by: JF. - MMJ
Date: 08/11/11 08/11/18

Audited by: JL
Date: 08/11/21

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D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>	REV. B SHEET 1 OF 1
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>
REV <b>B</b>	DATE <b>06.11.07</b>	DESCRIPTION <b>INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM</b>

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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